

Date: Wednesday, 12/7/2005 8:26:49 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BAFFLE ASSEMBLY
<b>Job Number</b> : 25152	
<b>Estimate Number</b> : 11265	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3276042
<b>This Issue</b> : 12/7/2005 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3276 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : N/A	<b>Material</b> : N/A
<b>Written By</b> : See comment below	<b>Due Date</b> : 12/30/2005
<b>Checked &amp; Approved By</b> : See comment below	<b>Qty:</b> 30 Um: 4 Each
<b>Comment</b> : Est Rev:A New Issue 05-12-06 JLM	22

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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**Comment:** Qty.: 1.0715 sf(s)/Unit Total: 10.7153 sf(s) M19059 = 294 inch<sup>2</sup>  
 Material: 6061-T6 (QQ-A-250/11) 0.040" thick  
 (M6061T6S.040) ~~M4845~~ 294 inch<sup>2</sup>  
 Batch: ~~M4845~~ M4845

2.0	SHEAR	SHEAR
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**Comment:** SHEAR

Cut blank: 8.975" x 16.375" grain along 8.975"

JL 05-12-12 16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA498 and Dwg D3276

JL 05-12-12 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

JL 05-12-12 16

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

EP 05/12/12 16

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SB 05/12/12 4 23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
05/12/13	3	Took 1 for Template on -041	SB	05/12/13	1	<i>[Signature]</i> 05/12/13		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 06/01/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 25152

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Roll as per Dwg D3276

SB 05/12/14.23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3276

SB 05/12/14.23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

TF 05/12/15 22

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ML 05.12.15 22

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

D2464

3/4 Seal



Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s)

Pick:

Qty Part Number Description Batch

27.0" D2464 Neoprene Seal B 21404

324" 270"

B21404 B25153

SB 05/12/15 22

14.0

D32763

Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3276-3 Decal B22545

SB 05/12/15 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 12/7/2005 8:26:50 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 25152

Part Number: D3276042

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276

SB 06/01/03

22

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-03

22

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06/01/04

22

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

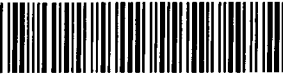
Inspection Level 21

5.15 06/01/04

(22)

06/01/04 (22)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

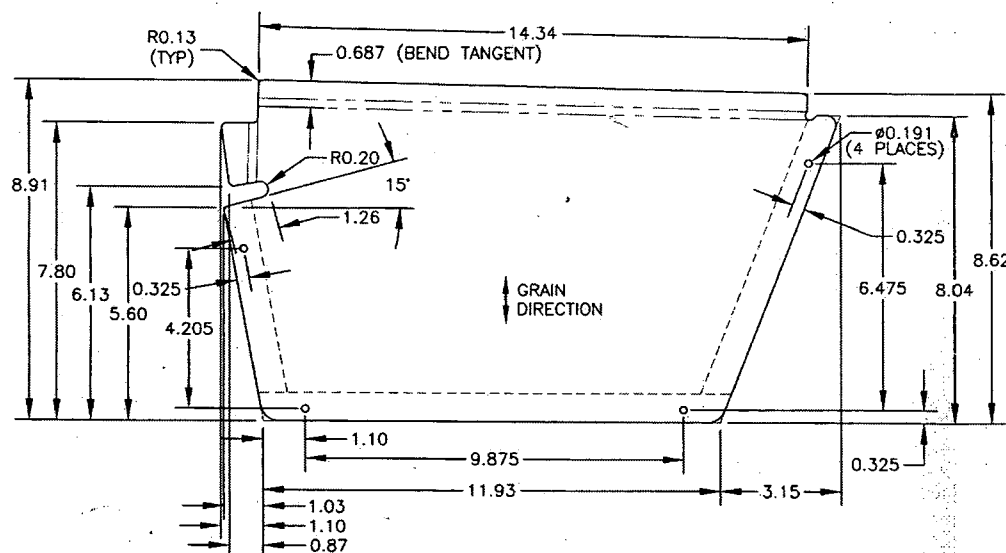
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

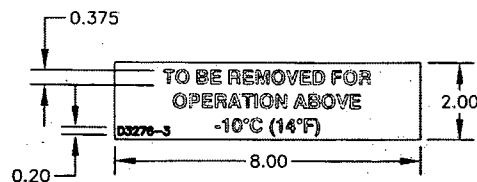
NOTE: Date & initial all entries





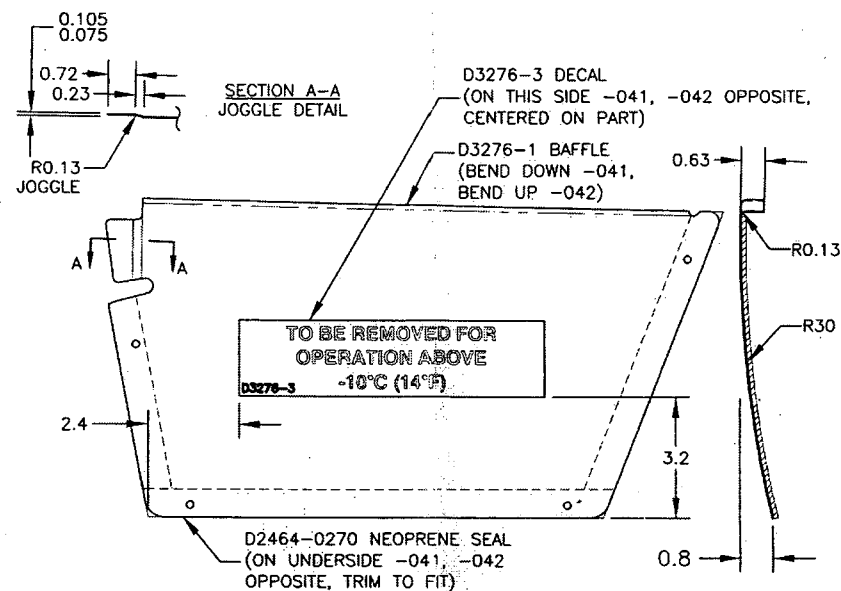
#### D3276-1 BAFFLE (FLAT PATTERN)

- 1) MACHINE PER DWG FILE "D3276-A.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)  
(REF DART SPEC. M6061T6S.040)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-3 DECAL

- 1) RED LETTERING ON WHITE ADHESIVE BACK
- 2) MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)

#### D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)

RELEASED  
050207

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DART AEROSPACE LTD.

B	05.01.25	LABEL NOW -10°C; CURVE PART	
A	05.01.07	NEW ISSUE	
DESIGN	CP	DRAWN BY	CP
CHECKED	#	APPROVED	#
DATE	05.01.25	DRAWING NO.	D3276
		TITLE	BAFFLE ASSEMBLY
		REV. B	SHEET 1 OF 1
		SCALE	1:3

**DART** DART AEROSPACE LTD.  
WILKESBURY, ONTARIO, CANADA



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